

Date: Friday, 23/05/2008 9:54:53 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CLAMP
Job Number :	39440		
Estimate Number :	10267		
P.O. Number :		Part Number :	D2438
This Issue :	23/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2438 REV. C
First Issue :	1/1	Project Number :	N/A
Previous Run :	37852	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	JUL 08.5.23	Due Date :	15/06/2008
Comment :	Est: E 05.06.28 Bending removed KJ/JLM		

Qty: 200 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6432

~~Laser cut~~ as per Dwg D2438

CFI

Material release note is required

C208/05/23

(200)

2.0	D2438B	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)

CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

Pc 8/13

(200)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

S 08/06/16

counter

(196) 201

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

C208/07/16

(201)

counted

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:54:53 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 39440

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



center

Comment: INSPECT WORK TO CURRENT STEP

S 08/07/16 (x201)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 455 (*overstock*)

JS 08/07/17 (x201)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/18 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-07-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

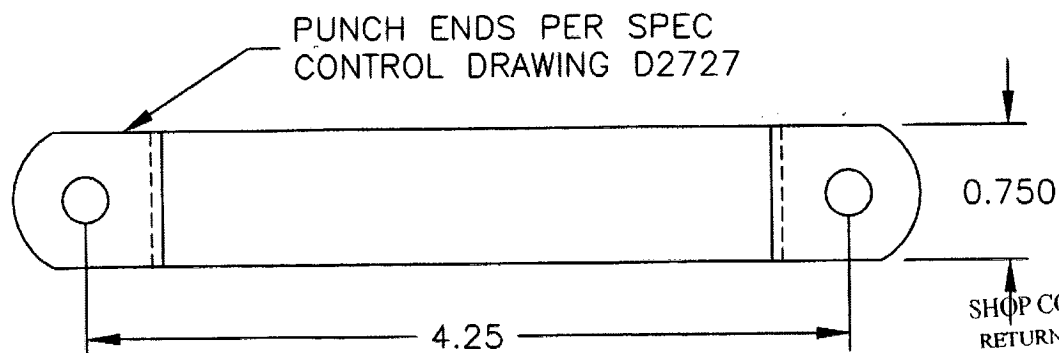
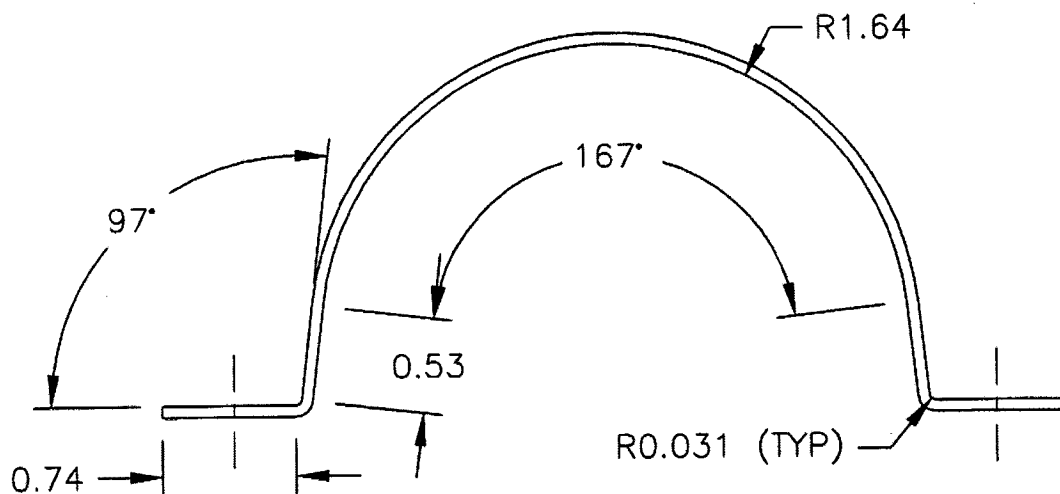
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KEPUNCH ENDS PER SPEC
CONTROL DRAWING D2727

FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39440# 00.06.06
CP 00.06.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VI. NDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/06/10	0395783

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299		J0183810	PO00006432	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
200	D2438B	CLAMP CUT&FORMED		

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS

RECU PAR / RECEIVED BY

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 17 OUR JOB NO J0183810 SHIPPING MEMO 0395783

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>-</u>	<u>200 PCS</u>	<u>PO00006432</u>	<u>D2438B</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>

MATERIAL S.S.T 304 SUPPLIED BY TW METALS / NORTH AMERICAN MAT. REL. NO. 2MW9

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u></u>	<u></u>	<u></u>
3	<u></u>	<u></u>	<u></u>
4	<u></u>	<u></u>	<u></u>
5	<u></u>	<u></u>	<u></u>
6	<u></u>	<u></u>	<u></u>
7	<u></u>	<u></u>	<u></u>
8	<u></u>	<u></u>	<u></u>
9	<u></u>	<u></u>	<u></u>

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 11 JUNE 2008

G.F.I. Q.C. REP. Dart Aerospace Ltd



~~9742-091 REV 0 Bombardier Certificate of Compliance~~
~~TW Metals District Procedure~~

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

~~FRAUD AND FALSIFICATION STATEMENT~~

~~The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, Title 18 chapter 47.~~

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GEI

PURCHASE ORDER No. 0073225

ITEM No. 0001

SHIPPER INVOICE No. 03232573

MATERIAL: 304-2B

SPECIFICATION: ASTM A262

MANUFACTURING MILL: North American Stainless

SIZE: 062

HEAT / LOT No. 2MW19

PART No. T506348X964A

QUANTITY: 125.432 LB.

TEST DEPARTMENT CLERK: Jessie Clark

AUTHORITY:

Joe Schab
Director of Quality Assurance



METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 366147 02 Mail To:

Customer: 0018 001

Ship To:

Date: 7/11/2007 Page: 1

Steel: 302/304/304L

Finish: 2B

Your Order: 01010133

NAS Order: AN 0373673 01

Corrosion: ASTM A262/G2aE, 180 Bend OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/06b, 480/06b, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-AXMG FRM, AMS5511H/5513H/5516F, AMD3, X CRWN MEAS

REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.
EN 10204 3.1; Q08763F Cond A; RoHS Compliant
* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
022MW9 A	* 022MW9 A	.0620	36.0000	20,700 COIL	2778.9	11	1	

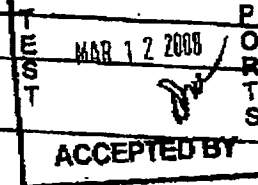
CHEMICAL ANALYSIS

Heat	CM	C	CR	CU	MN	MO	N	NI	P	S	SI
2MW9	US	.025	18.329	.298	1.832	.311	.072	8.113	.026	< .001	.332

MECHANICAL PROPERTIES

Product ID #	Coil #	Id of c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard	Grain No.
022MW9 A	022MW9	F T	95.50	48.52	48.03	86.50	82.50	8.000

TW METALS



REVIEWED BY Q.C.
Date 7/13/07 by

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

7/11/2007

Size: 304/L ANI 050-066 ANS 5512/11
Customer: TW Metals-Cincinnati
Heat: 2MW9
Sales: 01106395
QTY: 8
Shipped: 02/29/08 49189775

Michael Howell
Mike Howell

49189775